

Work Order ID 67996

Tuesday, April 05, 2011 10:46:27 AM

Page 1

Item ID: D4380-19

Accept

Revision ID: PRELIM

Item Name: Cover, Dimmer Box

Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 4/5/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan: MFDate: 11-04-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4380	PAG <u>PAZ</u> <u>DL</u> <u>11/04/05</u> <u>ADA</u>	0.00							

100



HandThermo

Memo

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

0.00

105



HandThermo

Dry Material

Memo

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

0.00

Temp: 150°FTime IN: 6:00 pm 11/04/04Time OUT: 7:00 am 11/04/05**PRELIMINARY ISSUE**BB
11/04/05BB
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA119 using tool DT9744

Dwg Rev: PA7
Folio Rev: A

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Visually inspect part for proper formation and texture

130

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

11/04/05

11/04/05

11/04/05

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Page 3

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Required Date: 4/5/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

Jh
11/04/05

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

Jh
11/04/05

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

- inspected to P27
Dwg only
8/11/04/06 (X)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 67996

Tuesday, April 05, 2011 10:46:27 AM



Page 4

Item ID: D4380-19 Accept

Revision ID: PRELIM

Item Name: Cover, Dimmer Box

Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 4/5/2011 Req'd Qty: 1.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>REDUCE</i>	0.00							
	Packaging	Memo							
	Packaging								
180	QC21- Final Inspection - Work Order Release	0.00							
	QC	Memo							
	Quality Control								

11/15/16

RD 23 20

POSITIVE RECALL
EFFECTIVE *11/05/13* AUTH *MF*
RELEASED *UP* DATE *11/05/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:46:25 AM

Page 1

Work Order ID: 67996

Parent Item: D4380-19

Parent Item Name: Cover, Dimmer Box



Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue. 11/04/04 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

Loc Qty

Loc Code

therm

787.2912

116576

787.2912

3.46875 sq ft.

Dfk
2/04/06

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67986
Description:		Part Number: D4380-19
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than $\frac{1}{4}$ "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL	Date: 11/04/05
------------------------	-----------------------

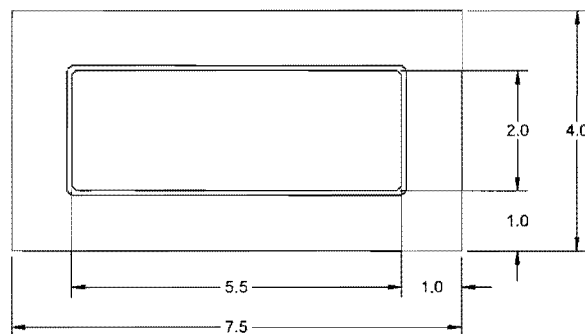
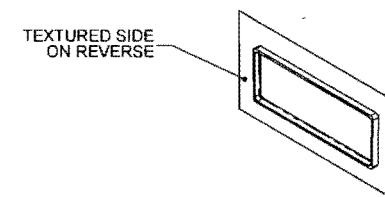
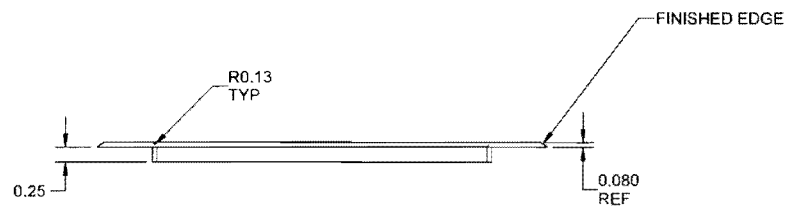
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.5"	$\pm .100$ "	7.5"	✓		Tape DL-01	
5.5"	$\pm .100$ "	5.45"	✓		Caliper DL-02	
2.0"	$\pm .100$ "	1.977"	✓		Caliper DL-02	
4.0"	$\pm .100$ "	4.0"	✓		Tape DL-01	
1.0"	$\pm .100$	1.0"	✓		Tape DL-01	

Measured by: DL	Date: 11/04/05
Audited by: S to P22 Dan in by	Date: 11/04/06
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



D4380-19 COVER, DIMMER BOX

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -19 PART PER MOULD DT9744.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE

DL 11.04.05

DESIGN	<i>DL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DL</i>		
CHECKED		DRAWING NO. D4380	REV. PA7
MFG. APPR.			SHEET 10 OF 19
APPROVED		TITLE CÉILING POCKETS	SCALE NTS
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DATE	11.04.05		

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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Dart Aerospace Ltd

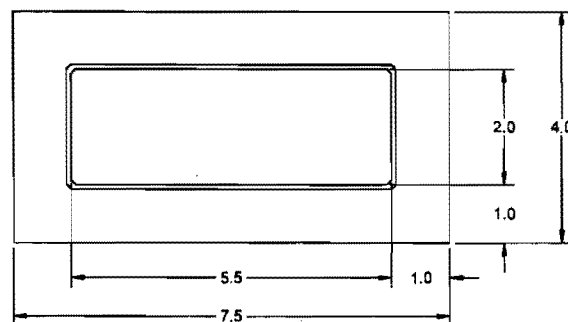
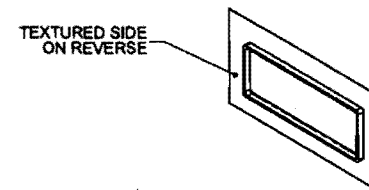
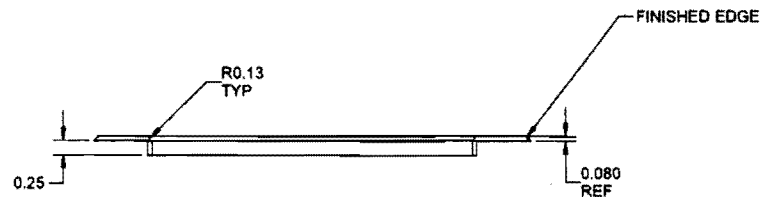
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D4380-19 COVER, DIMMER BOX

67996

RELEASED
2011-05-10
JND

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.08 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9744 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE
- 11) MAXIMUM INSIDE RADIUS = 0.188

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4380	SHEET 10 OF 19
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CEILING POCKETS	NTS
DATE	11.04.21	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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